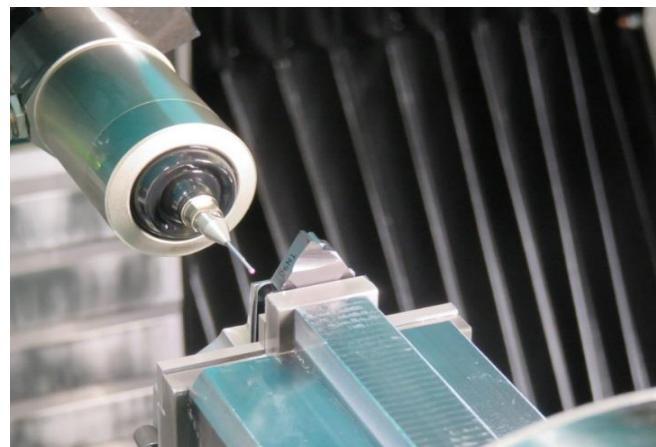
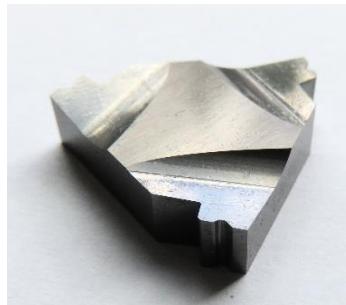


Insert 6204 Z3 IDØ12.7

A08-200

Pregrinding of the corner uses a 1A1 and is executed in 2 plunges. Finishing of the profile uses standard profiling process with pointed wheel. The chipbreaker is executed in oscillationmode generating the bottom radius of 3 mm. The below mentioned cycletime is per side.



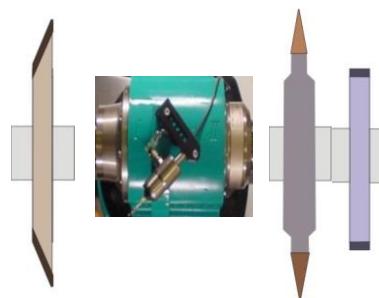
1. Cycletime for Production

Workpiece:	Triangle IDØ 12.7 T4.76 Material CERMET					
Operations						
Probe						
Pregrinding						
Finishing						
Polishing 1						
Polishing 2						
Chipbreaker						
Feed [mm/Min]	2000	5	6	15	22	2400
Power [kW]		4	3	2	2	2
Cutting speed [m/s]		20	20	20	20	20
Used wheels						
Grinding time [s]	18	120	118	53	37	139
Total cycle time	8 Min 5					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64 MH
2	14EE1 Ø200 D46V20°
3	1V1 Ø180 D54



3

2 1

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGS

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iB 5

Software: Quinto 5

Accessories: RPC

Responsible engineer: OP, 13.7.16

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